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D2344**Job Sheet 195904****Part No:** D2344**Job Qty:** 20 pcs**Part Name:** Deck Plate Aft**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/31/19**Job Tracking No:****Due Date:** 7/2/19**Created By:** Kimberley Guerin**Type:** Stock**Description:****Note:** DWG REV F IPP Rev:D 00.06.26 Removed P/O for powder coat EC IPP Rev:E 07-07-04 Asper Rev F JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		7/2/19	0.11	3.23	Waterjet - Flow		JRB 6/19/19
110	QC 2	20 pcs		7/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	20 pcs	7/2/19	0.00 0.00	QC 2 - 65	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 6/19/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	DAS
				QC 8 - 47	40
				QC 8 - 40	JUN 20 2019 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - 2 - B4B	20 pcs	7/2/19	0.00 2.65	Small Fab - 1 - B4B	SMB 19/6/25
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
140 QC 5	20 pcs	7/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	JUN 25 2019 DAS 40 9-89
150 Handfinish - 1-1 Chemical- B4B	20 pcs	7/2/19	0.00 1.10	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	☆ JUN 25 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	

				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
155	QC 7	20 pcs	7/2/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
160	Powdercoat - 4 Black Sand - B4B	20 pcs	7/2/19	0.00 0.72	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B

BR 19-6-25

M 138940

160 Powdercoat - 4 Black Sand - B4B

START: 3:20 OUT: 390° FINISH: 3:50

BR 19-6-25

DAS
70
9-89

QC 21 - SA - 53

Part Op 100 - 1-Cut as per dwg prog rev: _____ dwg rev: _____

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Small Fab) 1-Deburr sharp edges 2-Countersink holes per Dwg D2344

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

155 - (QC7-Inspect Chemical Conversion Coat)

160 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	14.9000 sf (.745 ea)	100-Waterjet - Flow - 1	5101786 x 1

5165803 x 1 11

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	15	149	0

5146235 x 1 11

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Litter Deck Plate Kit (350)	6.223Inches ± 0.010	6.233 6.213	6.223	Tape
2	Litter Deck Plate Kit (350)	5.598Inches ± 0.010	5.608 5.588	5.599	VDC-02
3	Litter Deck Plate Kit (350)	4.869Inches ± 0.010	4.879 4.859	4.866	
4	Litter Deck Plate Kit (350)	3.889Inches ± 0.010	3.899 3.879	3.889	
5	Litter Deck Plate Kit (350)	3.096Inches ± 0.010	3.106 3.086	3.097	
6	Litter Deck Plate Kit (350)	2.891Inches ± 0.010	2.901 2.881	2.890	
7	Litter Deck Plate Kit (350)	16.973Inches ± 0.010	16.983 16.963	16.973	
8	Litter Deck Plate Kit (350)	0.450Inches ± 0.010	0.460 0.440	0.450	
9	Litter Deck Plate Kit (350)	4.423Inches ± 0.010	4.433 4.413	4.423	
10	Litter Deck Plate Kit (350)	4.723Inches ± 0.010	4.733 4.713	4.723	
11	Litter Deck Plate Kit (350)	1.202Inches ± 0.010	1.212 1.192	1.200	
12	Litter Deck Plate Kit (350)	5.869Inches ± 0.010	5.879 5.859	5.866	
13	Litter Deck Plate Kit (350)	4.654Inches ± 0.010	4.664 4.644	4.654	
14	Litter Deck Plate Kit (350)	0.656Inches + 0.005 - 0.000	0.661 0.656	0.658	Diameter
15	Litter Deck Plate Kit (350)	1.888Inches ± 0.010	1.898 1.878	1.888	
16	Litter Deck Plate Kit (350)	2.285Inches ± 0.010	2.295 2.275	2.285	
17	Litter Deck Plate Kit (350)	2.683Inches ± 0.010	2.693 2.673	2.684	
18	Litter Deck Plate Kit (350)	0.171Inches + 0.005 - 0.000	0.176 0.171	0.173	Diameter
19	Litter Deck Plate Kit (350)	3.491Inches ± 0.010	3.501 3.481	3.490	
20	Litter Deck Plate Kit (350)	0.191Inches + 0.005 - 0.000	0.196 0.191	0.193	Diameter
21	Litter Deck Plate Kit (350)	3.123Inches ± 0.010	3.133 3.113	3.120	
22	Litter Deck Plate Kit (350)	1.975Inches ± 0.010	1.985 1.965	1.975	
23	Litter Deck Plate Kit (350)	0.128Inches + 0.005 - 0.001	0.133 0.127	0.128	Diameter

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JRB 6/19/19



Container No: S191851



Part: D2344

Job No: 195904

Serial No/Batch: S191851

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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